

FIG.1

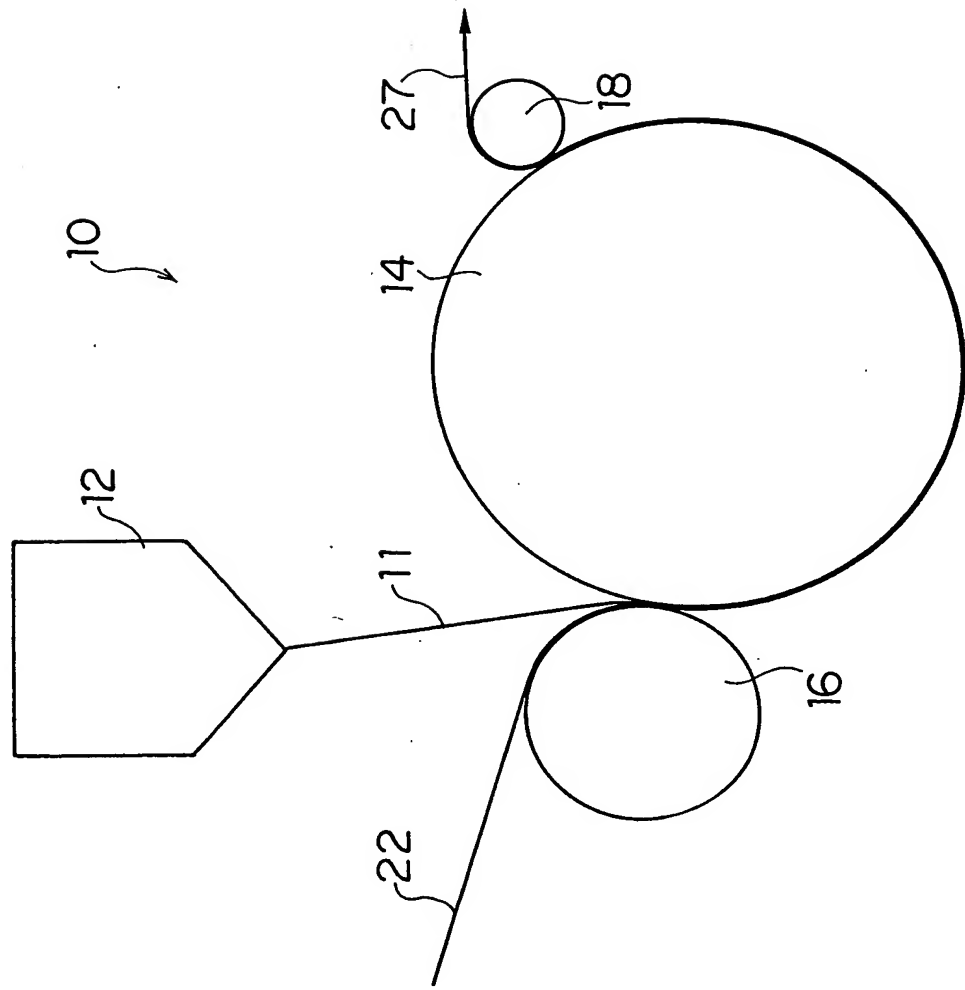


FIG.2(a)

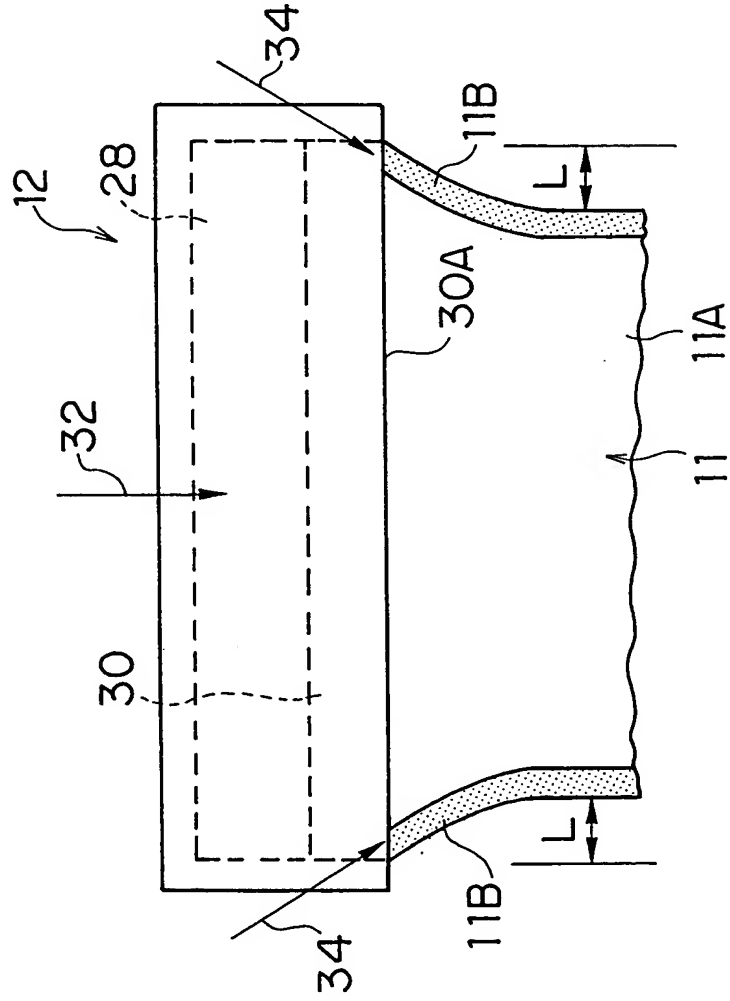
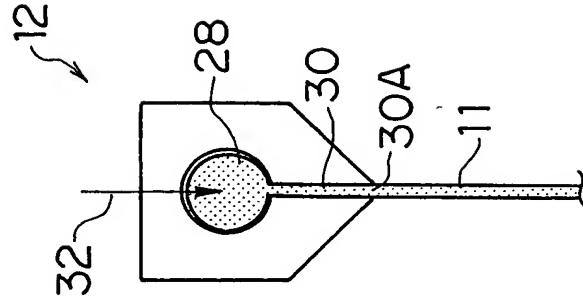


FIG.2(b)



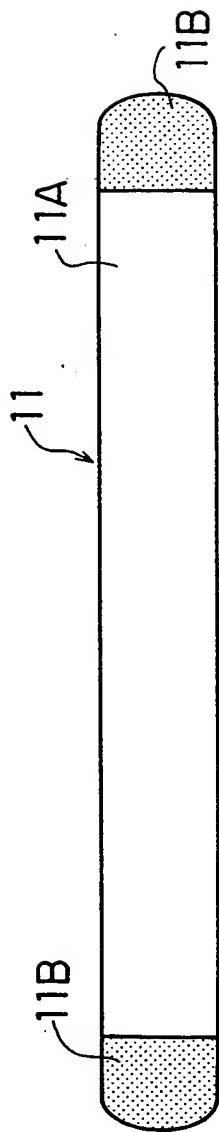


FIG. 3(a)

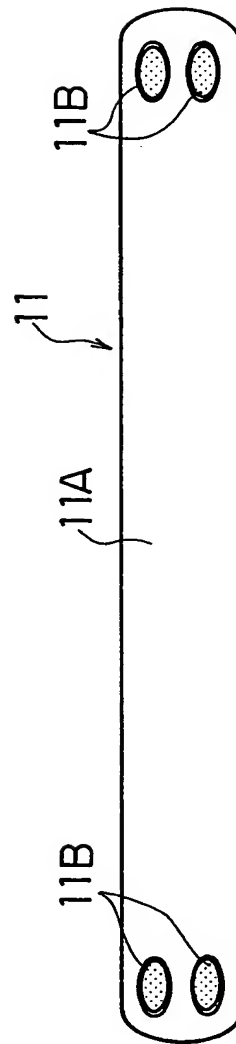


FIG. 3(b)

FIG.4

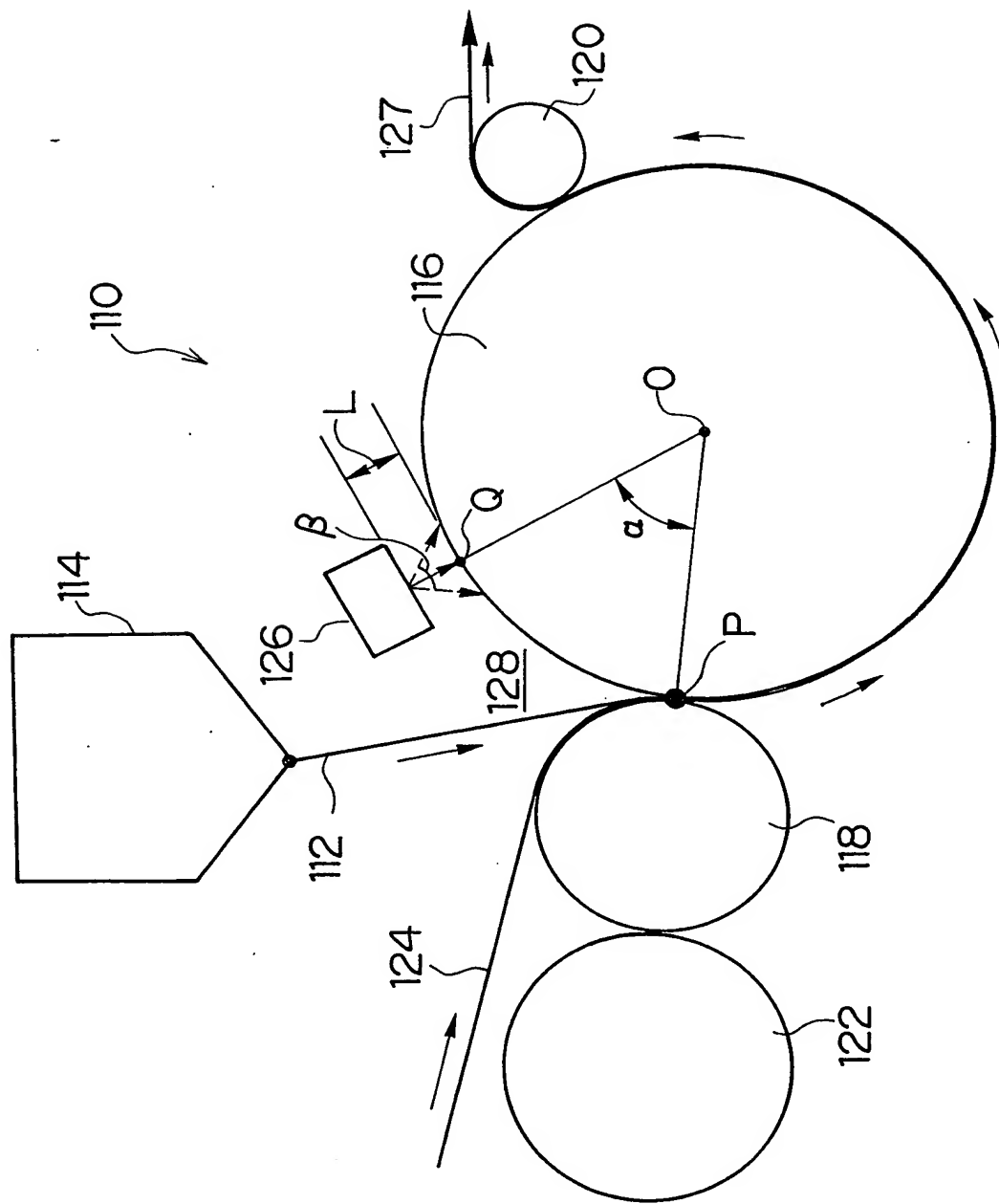


FIG.5

	LINE SPEED (m/min)	MFR OF END RESIN (g/10min)	MFR RATIO OF END RESIN	EXTENSION VISCOSITY RATIO	SECTIONAL SHAPE OF RESIN FILM AT JOINING PART	NECK-IN AMOUNT OF ONE SIDE (mm)	PRESENCE OF FILM SEPARATION
COMPARATIVE EXAMPLE 1	200	10.0		1.0	Fig.3(b)	30	ABSENCE
COMPARATIVE EXAMPLE 2	200	20.0	2	1/3	Fig.3(b)	34	ABSENCE
EXAMPLE 1	200	8.0	4/5	1.2	Fig.3(b)	25	ABSENCE
EXAMPLE 2	200	12.0	1.2	1.2	Fig.3(b)	28	ABSENCE
EXAMPLE 3	200	8.0	4/5	0.9	Fig.3(b)	29	ABSENCE
EXAMPLE 4	420	2.0	1/5	10	Fig.3(b)	9	ABSENCE
COMPARATIVE EXAMPLE 3	420	2.0	1/5	10	Fig.3(a)	ESTIMATE DISABLE	PRESENCE

FIG.6

	LINE SPEED (m/min)	DISTANCE FROM NIP POINT (DEGREE)	DISTANCE FROM COOLING ROLLER (mm)	GAS WIND VELOCITY (m/s)	GAS BLOWING DIRECTION	WINDSHIELD PLATE	CRATER RESULT (PIECE)
COMPARATIVE EXAMPLE 4	300	—	—	—	—	—	350
COMPARATIVE EXAMPLE 5	300	45	20	3	NIP POINT	—	100
COMPARATIVE EXAMPLE 6	300	45	60	3	ROLLER SURFACE	—	200
COMPARATIVE EXAMPLE 7	300	100	20	3	ROLLER SURFACE	—	210
COMPARATIVE EXAMPLE 8	300	45	20	0.5	ROLLER SURFACE	—	190
COMPARATIVE EXAMPLE 9	300	45	20	3	NIP POINT	—	250
COMPARATIVE EXAMPLE 10	400	45	20	3	NIP POINT	PRESENCE	115
EXAMPLE 5	300	45	20	3	ROLLER SURFACE	—	40
EXAMPLE 6	400	45	20	3	ROLLER SURFACE	—	50